

Work Order ID 74138

Monday, September 26, 2011 8:50:27 AM

Page 1

Item ID: D3916-5

Accept

Revision ID:

Item Name: Light Rib

Start Date: 9/27/2011 Start Qty: 2.00

Required Date: 9/27/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9566

*** Make line at 9.00" annd use jig for other line***

3- Trim access tube material to finish size as per dwg D3916

110

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

(2)

PLC 11.09.26 (2x)

PLC 11.09.26 (2x)

Work Order ID 74138

Page 2

Monday, September 26, 2011 8:50:27 AM

Item ID: D3916-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Rib

Start Date: 9/27/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

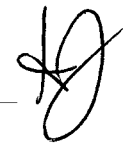


QC

Memo

0.00

Quality Control

11/9/27 
MS
11-09-26

Picklist Print

Monday, September 26, 2011 8:50:25 AM

Page 1

Work Order ID: 74138

Parent Item: D3916-5

Parent Item Name: Light Rib



Start Date: 9/27/2011

Required Date: 9/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

969.3959

4.166

8.770526



Square Tubing



SAD 11-09-26

Location

Loc Qty

Loc Code

MAT034

969.3958658

116610

0.8383

117721

0.3234

117999

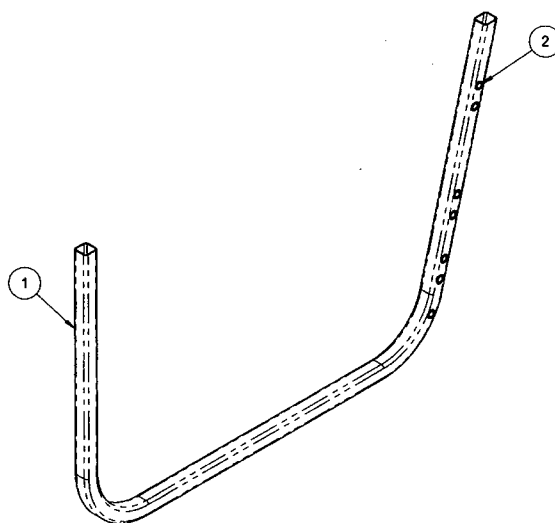
384.234166

118460

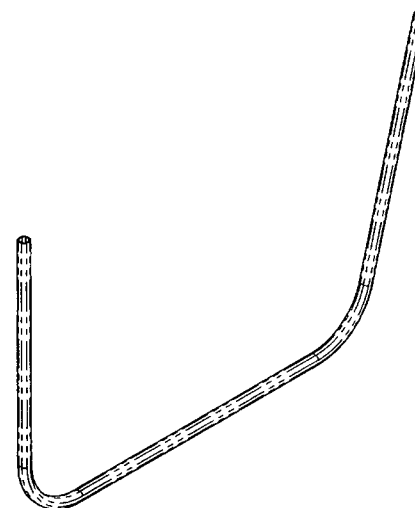
584

8.7706

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



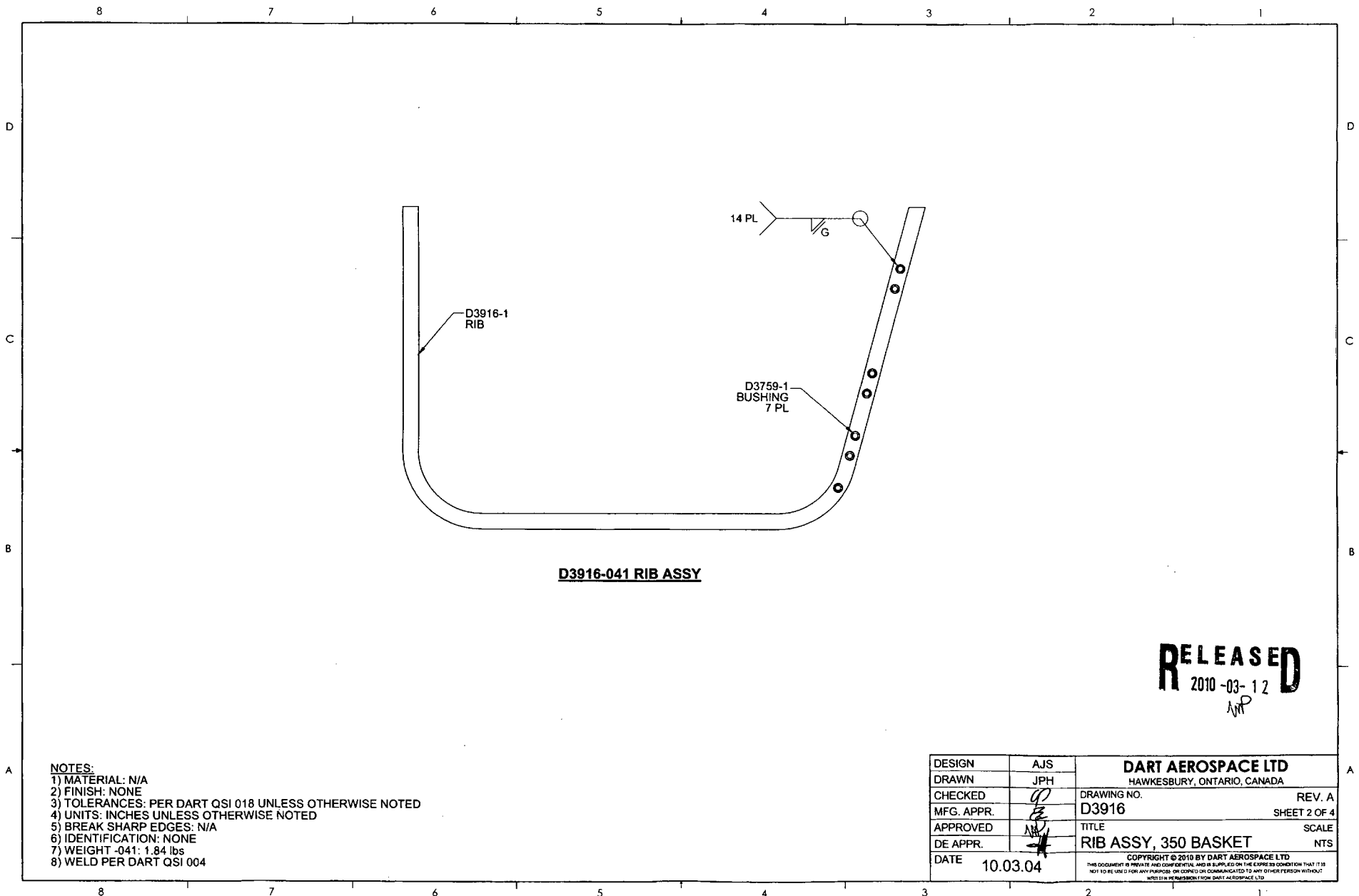
D3916-5 LIGHT RIB

OK 10.12.21
 UNDER REVIEW
 10.10.11
 ADDITION OF HOLE + BUSHING
 ON D3916-041-1 RIBS.

RELEASED
 2010-03-12
 JNP

no 74138

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D3916	SHEET 1 OF 4
APPROVED	<i>JNP</i>	TITLE	SCALE
DE APPR.	<i>JNP</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

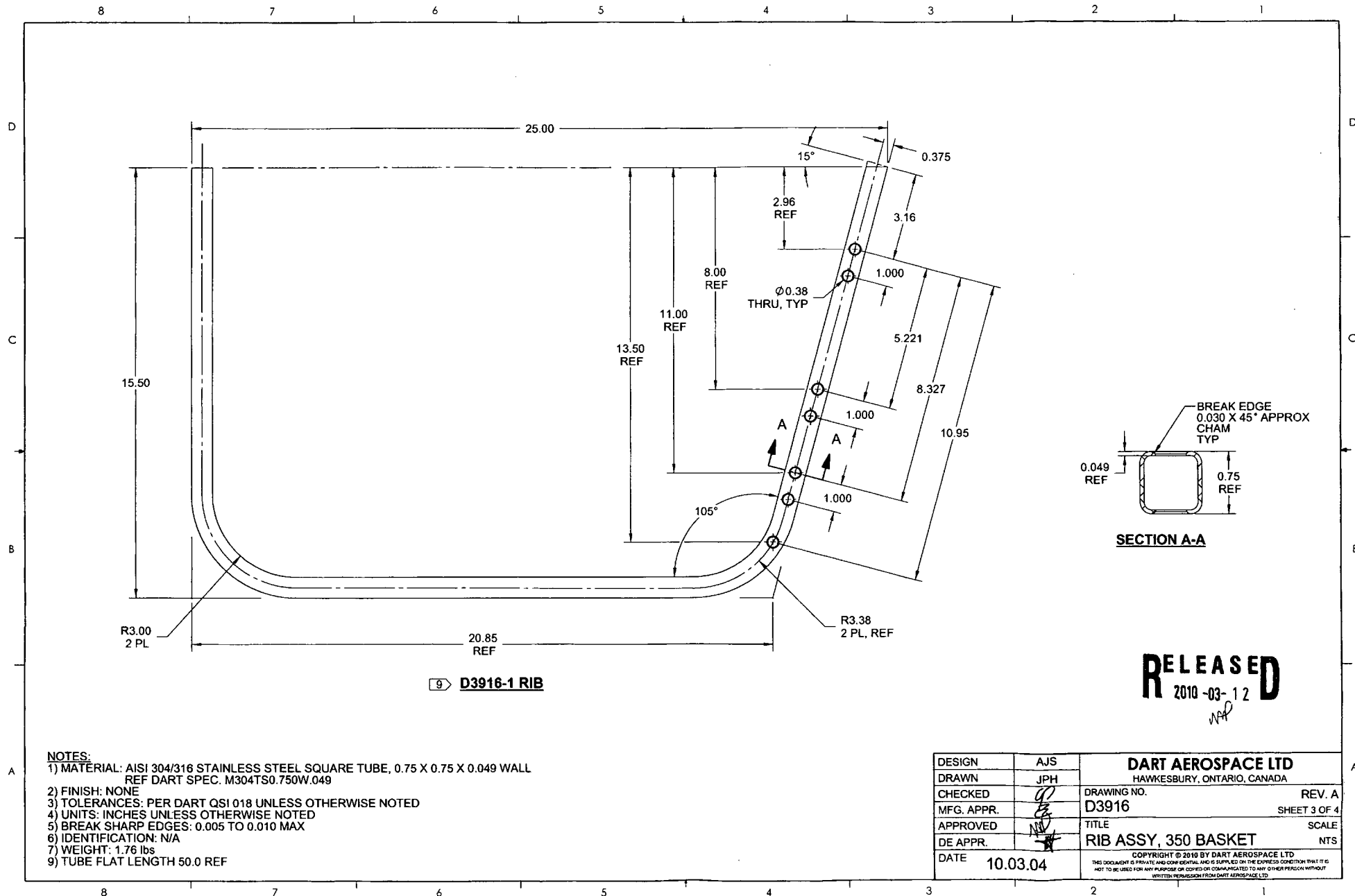


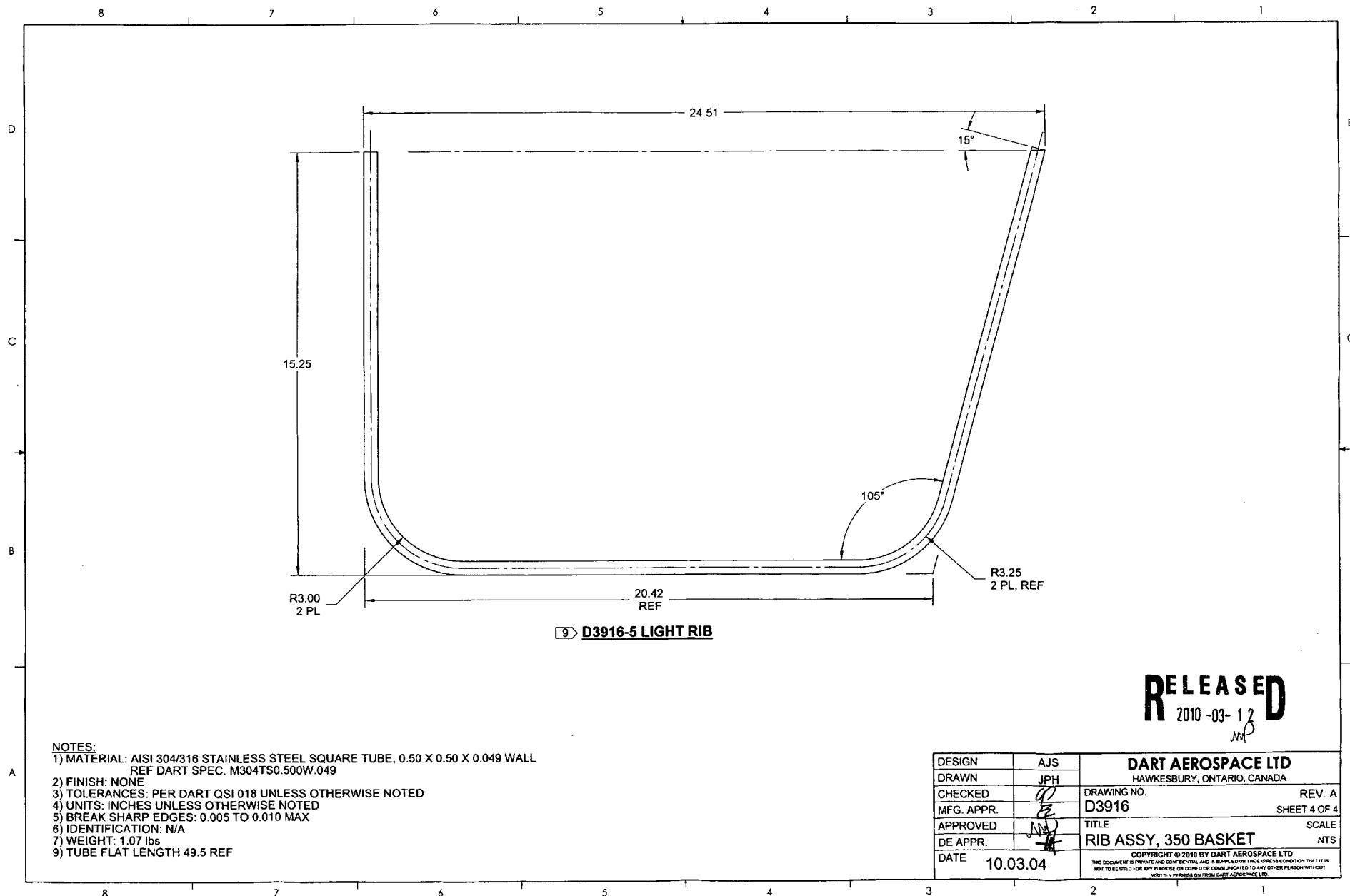
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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RELEASED
2010-03-12
[Signature]





RELEASED
2010-03-13

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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